

Date: Tuesday, 9/11/2007 10:28:02 AM
 User: Kim Johnston

Process Sheet

40

Customer	CU-DAR001	Dart Helicopters Services	Drawing Name	BASKET LID ASSEMBLY		
Job Number	34536B					
Estimate Number	10207					
P.O. Number	N/A					
This Issue	9/11/2007	S.O. No.	N/A	Part Number	D2989043	
Prsht Rev.	NC			Drawing Number	D2989 REV B	
First Issue	N/A	Type	LARGE FAB ASSY	Project Number	N/A	
Previous Run	34535B			Drawing Revision	B	
Written By				Material	N/A	
Checked & Approved By				Due Date	10/5/2007	
Comment	Est Rev:I	Removed D2989-041	05-11-03	Qty:	1	Um: Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	D31821	Hinge	
		Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)	
		Pick:	
	Qty Part number	Description Batch	
	2 D3182-1	Hinge <u>B33192</u>	<u>Pjl 07-10-04</u>
2.0	D34423	Shim	
		Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)	
		Pick:	
	Qty Part number	Description Batch	
	2 D3442-3	Shim <u>B33281</u>	<u>Pjl 07-10-04</u>
3.0	M304EX07516F	Expanded Metal Flat Stai	
		Comment: Qty.: 8.0000 sf(s)/Unit Total : 8.0000 sf(s)	
		Pick:	
	Qty Part number	Description Batch	
	8sf M304EX0.75-16F	Expanded Metal <u>m105497</u>	<u>Pjl 07-10-04</u>
4.0	M304TS0750W065	304 SQ Tube.75x.75x.065W	
		Comment: Qty.: 17.6400 ft(s)/Unit Total : 17.6400 ft(s)	
		3/4" x 3/4" x 0.063" wall 304/316 SStubing.	
	Batch:	<u>m105604</u>	<u>Pjl 07-10-04</u>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: PD Date: 07/16/10
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 9/11/2007 10:28:02 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BASKET LID ASSEMBLY

Job Number: 34536B

Part Number: D2989043

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Cut (4) D2236-1 From D3166-3 As Per Dwg D2989

Note: D2989-3/-4 On -041 Bom

2-Drill holes in tubing as D2989-043 per Dwg D2989

3-Deburr and remove all markings on material

4-Weld as per Dwg D2989 and D2989-043 Assembly using Welding Table and corner Jig. Deburr as required

Note: Expanded metal "diamonds" must run lengthwise. Eg 2.0" along length of lid

07/10/04

6.0 QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PD 07-10-09

7.0 QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

PD 07-10-09

8.0 POWDER COATING

POWDER COATING



M105068

Comment: POWDER COATING

1-Powder Coat White (Ref. 4.3.5.2) D2989-041 as per QSI 005 4.3 & Dwg D2989

07-10-09 ①

9.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: Inspect Powder Coat

07/10/04

10.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/10/04

Job Completion



07/10/04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN DS	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>HT</i>	APPROVED <i>HT</i>	DRAWING NO. D2989	REV. B SHEET 1 OF 3
DATE 05.06.07		TITLE BASKET LID ASSEMBLY	SCALE NTS
A	00.10.27	NEW ISSUE	
B	05.06.07	ADD SHIM UNDER HINGES, UPDATE LID DIMENSIONS	

RELEASED05.08.19 *HT***PARTS LIST:**

Qty -041	Qty -043	Part Number	Description
X		D2989-041	BASKET LID ASSEMBLY (OUTSIDE)
	X	D2989-043	BASKET LID ASSEMBLY (INSIDE)
1		D2989-1	STRUT
1		D2989-2	STRUT
1		D2989-3	STRUT
1		D2989-4	STRUT
2		D2989-5	STRUT
2		D2989-7	STRUT
1		D2989-9	STRUT
1		D2989-10	STRUT
1		D2989-11	STRUT
1		D2989-12	STRUT
2		D2989-13	STRUT
2		D2989-15	STRUT
2		D2327-3	SPACER BUSHING
1		D2506	LABEL PLATE
2	2	D2989-17	STRUT (96.00" LONG)
2		D2989-19	STRUT (31.19" LONG)
1		D2512-7	STRUT
2		D2581	MOUNTING BRACKET
	2	D3182-1	HINGE
	2	D3442-3	SHIM

NOTES:

1) FRAME MATERIAL: AISI 304/316 SS, 3/4 x 3/4 x 0.060 WALL SQUARE TUBING
D2989-3/4/5/11/12/13 CAN BE MADE FROM D2236 UNCONTROLLED COPY
SUBJECT TO AMENDMENT

2) MESH MATERIAL: 3/4-16F EXPANDED SS (REF DART SPEC M304EX0.75-16F) WITHOUT NOTICE

3) WELD PER DART QSI 004

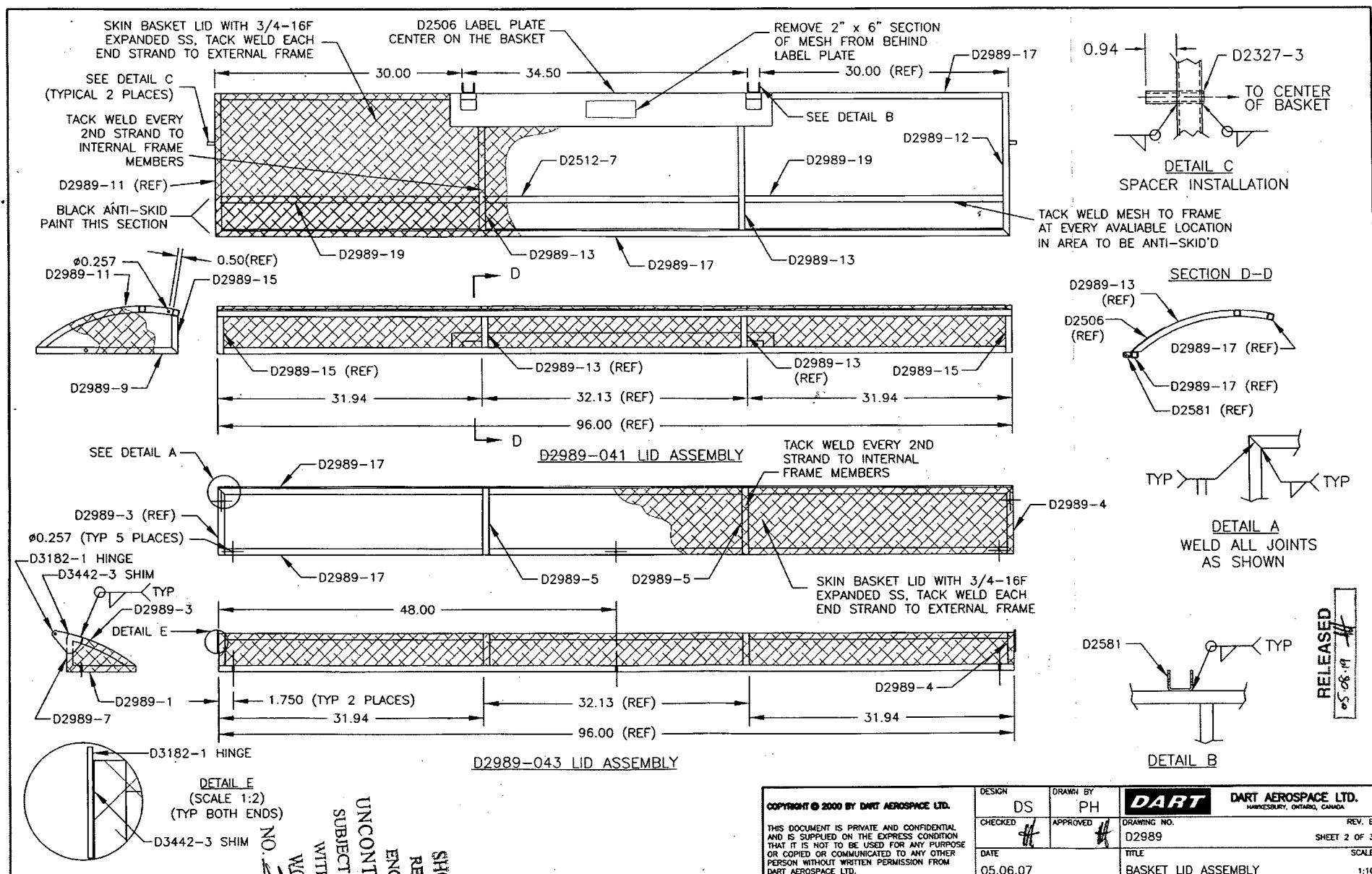
4) FINISH: POWDER COAT WHITE (REF. 4.3.5.2) PER DART QSI 005 4.3.
BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4. SPRAY PAINT
INSIDE SURFACE BLACK PRIOR TO APPLYING ANTI-SKID. WORK ORDER
NO. 34536B

5) ALL DIMENSIONS ARE IN INCHES

5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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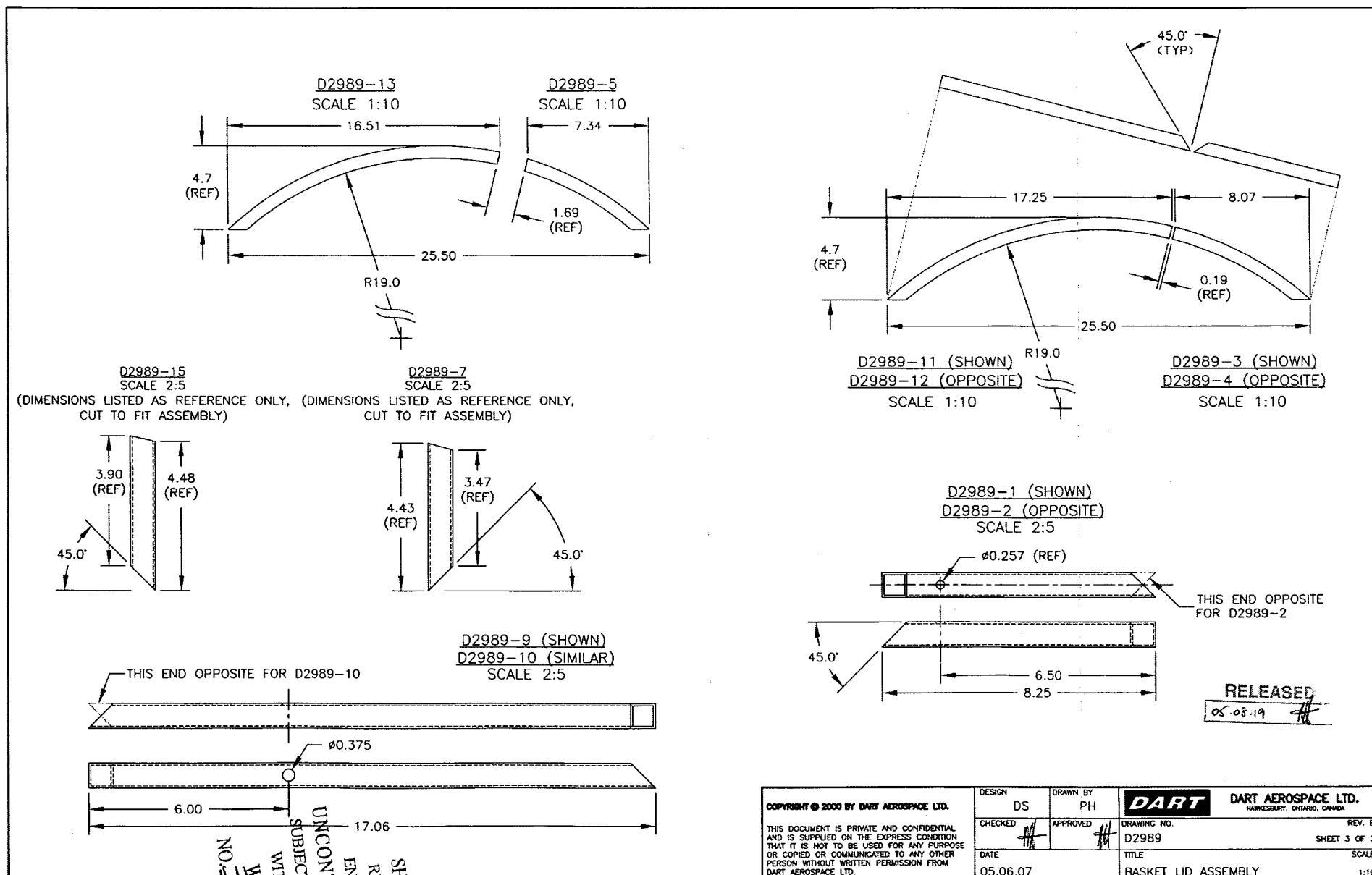
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2:
ENDS) NO. 345365
WORK ORDER SUBJECT TO AMENDMENT
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CHECKED <i>ff</i>	APPROVED <i>ff</i>	DRAWING NO. D2989	REV. B SHEET 2 OF 3
DATE 05.06.07	TITLE BASKET LID ASSEMBLY		SCALE 1:1



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		CHECKED <input checked="" type="checkbox"/>	APPROVED <input checked="" type="checkbox"/>	DRAWING NO. D2989	REV. B SHEET 3 OF 3
		DATE 05.06.07	TITLE BASKET LID ASSEMBLY	SCALE 1:10	